

Work Order ID 75190

October-18-11 3:26:26 PM

\*75190\*

Page 1

Item ID: D3319-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Wearplate

Stop

\*NS2\*

Start Date: 18/10/2011 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3319	Rev B
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100 0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

11-10-28

FLOW CNC Waterjet

1-Cut as per Dwg D3319 Dwg Rev: R Prog Rev: R 2-  
Deburr if necessary

1010 .479

(8)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

11-10-28

\*110\*

QC

Quality Control

Memo

0.00

120

QC8- Inspect parts - second check

0.00

11-10-31 (8)

\*120\*

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 75190**

**\*75190\***

October-18-11 3:26:26 PM

Page 2

**Item ID:** D3319-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

**Revision ID:**

**Item Name:** Wearplate

Stop

**\*NS2\***

**Start Date:** 18/10/2011 **Start Qty:** 8.00

**\*8\***

**Cust Item ID:**

**Required Date:** 04/11/2011 **Req'd Qty:** 8.00

**\*8\***

**Customer:**

**Reference:**

**Approvals:**

**Process Plan:** \_\_\_\_\_

**Date:** \_\_\_\_\_

**Tooling:** \_\_\_\_\_

**Date:** \_\_\_\_\_

Run Start

**\*NR1\***

**QC:** \_\_\_\_\_

**Date:** \_\_\_\_\_

**SPC (Y/N):** \_\_\_\_\_

**Date:** \_\_\_\_\_

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

130

**\*130\***

Small Fab

0.00

Small Fab

**Memo**

0.00

Small Fab

Deburr if necessary

NVR

140

**\*140\***

NC BRAKE

0.00

Brake NC

**Memo**

0.00

Brake NC

Form using DT8326 & DT8261 as per Dwg D3319Rev: b

Sa 11/10/11

(8)

150

**\*150\***

**QC**

QC6- Inspect dimensions to drawing

0.00

Quality Control

**Memo**

0.00

11 10 30 8

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 75190**

October-18-11 3:26:26 PM

**\*75190\***

Page 3

**Item ID:** D3319-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

**Revision ID:**

**Item Name:** Wearplate

Stop

**\*NS2\***

**Start Date:** 18/10/2011 **Start Qty:** 8.00

**\*8\***

**Cust Item ID:**

**Required Date:** 04/11/2011 **Req'd Qty:** 8.00

**\*8\***

**Customer:**

**Reference:**

**Approvals:**

**Process Plan:**

**Date:**

**Tooling:**

**Date:**

Run Start

**\*NR1\***

**QC:**

**Date:**

**SPC (Y/N):**

**Date:**

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

160

**\*160\***

Large Fab

0.00

(8)

MAL/CZ 11/11/18

Large Fab

**Memo**

0.00

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev:

Qty Part Number Description Batch A/R  
N/A 7560 Hardcoat Rod 1117741

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Quality Control

S u l u 1 2 1

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Quality Control

S u l u 1 2 1

(xs)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

Work Order ID 75190

\*75190\*

Page 4

October-18-11 3:26:26 PM

Item ID: D3319-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Wearplate

Stop

\*NS2\*

Start Date: 18/10/2011 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0:00

\*190\*

Powdercoat

Powder Coating

Memo

2:30

0.00

8x 8 m 11/11/21

200

QC3- Inspect Part Finish

0.00

\*200\*

QC

Quality Control

Memo

0.00

8x 8 M 11/11/21  
(Counted & Measured)

210

Packaging

0.00

\*210\*

Packaging

Packaging

Memo

0.00

Identify on inside surface using a permanent fine point marker with the  
following:TCCA-PDA, Dart Aerospace Ltd.P/N: D3319-3, B/N:  
BXXXXXXFor Product Eligibility see PDA05-18and  
StockLocation: 497

10/11/21 C

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID** 75190

\*75190\*

October-18-11 3:26:26 PM

Page 5

Item ID: D3319-3

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Wearplate

Stop

\*NS2\*

Start Date: 18/10/2011 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_

Tooling:

Date: \_\_\_\_\_

Run

Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

\*220\*

QC

Quality Control

Memo

0.00

11/11/22  
MF  
11-11-22

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

October-18-11 3:26:30 PM

Page 1

Work Order ID: 75190

**\*75190\***  
**\*D3319-3\***

Parent Item: D3319-3

Parent Item Name: Wearplate

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 8.00

Required Qty: 8.00

**Comments:** IPP: A05.05.12 New issue KJ/JLM  
IPP Rev:B Now on Waterjet 06-10-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	287.3000	3.2524	27.38863	**	1811-10-09	

**\*M1010S18GA\***

1010/1025 SHEET .048

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	287.3	
116268	21.5	
117806	265.8	117806

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	75190
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319	Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	C		T 1301	
74.420	+/-0.010	74.420	N		T	
62.770	+/-0.010	62.770	L		T	
52.890	+/-0.010	52.890	S		T	
30.790	+/-0.010	30.790	O		T	
8.690	+/-0.010	8.692	R		V BG2	
0.60	+/-0.030	.602	G		V	
2.690	+/-0.010	2.700	I		V	
2.940	+/-0.010	2.948	I		V	
3.527	+/-0.010	3.526	I		V	
4.518	+/-0.010	4.518	I		V	
Ø0.190	+0.005/-0.001	-191	S		V	
2.940	+/-0.010	2.947	G		V	
2.940	+/-0.010	2.946	I		V	
2.690	+/-0.010	2.700	I		V	
5.063	+/-0.010	5.061	G		V	
6.163	+/-0.010	6.160	S		V	
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	316x607	S		V	
0.048	+/-0.010	.048	I		V	

Measured by:	R	Audited by:	11.10.18	Prototype Approval:	N/A
Date:	11-10-18	Date:	<i>M/M</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM <i>JL</i>	<i>E</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75190

SHOP COPY

RETURN TO  
ENGINEERING

UNCONTROLLED COPY

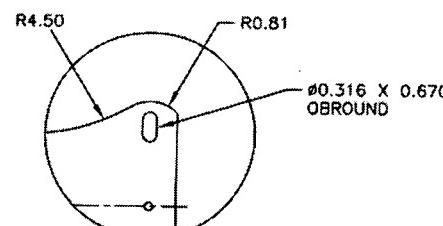
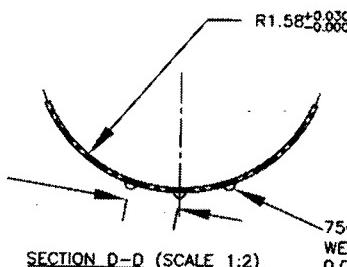
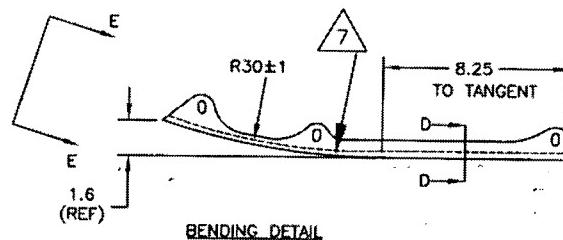
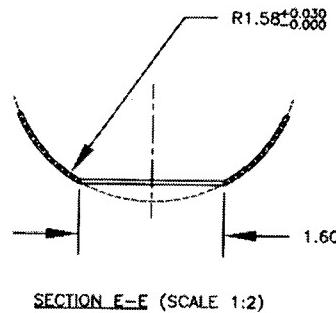
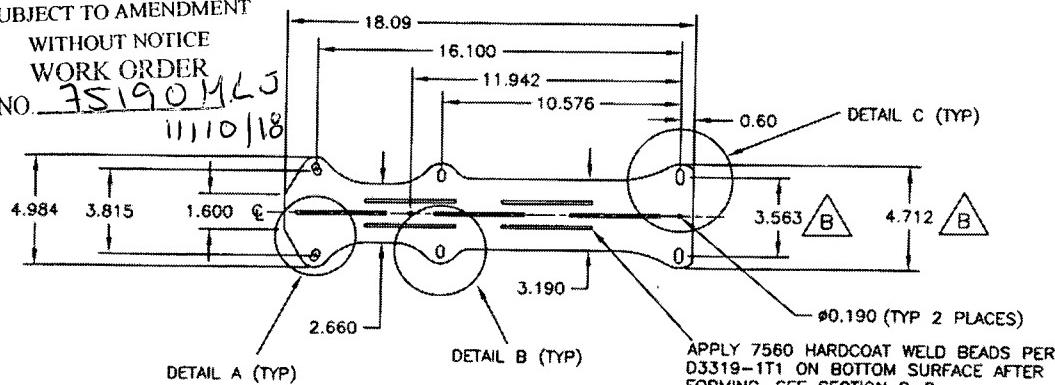
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 75190 MLJ  
111018

## FLAT PATTERN

DETAIL A  
(SCALE 1:4)DETAIL B  
(SCALE 1:4)DETAIL C  
(SCALE 1:4)

## D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A36/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE		DRAWING NO.	REV. B
05.06.06		D3319	
A	04.09.24	WEARPLATE	
B	05.06.06	NEW ISSUE	
		SHEET 1 OF 5	
		SCALE	1:8

**RELEASED**

05-09-34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

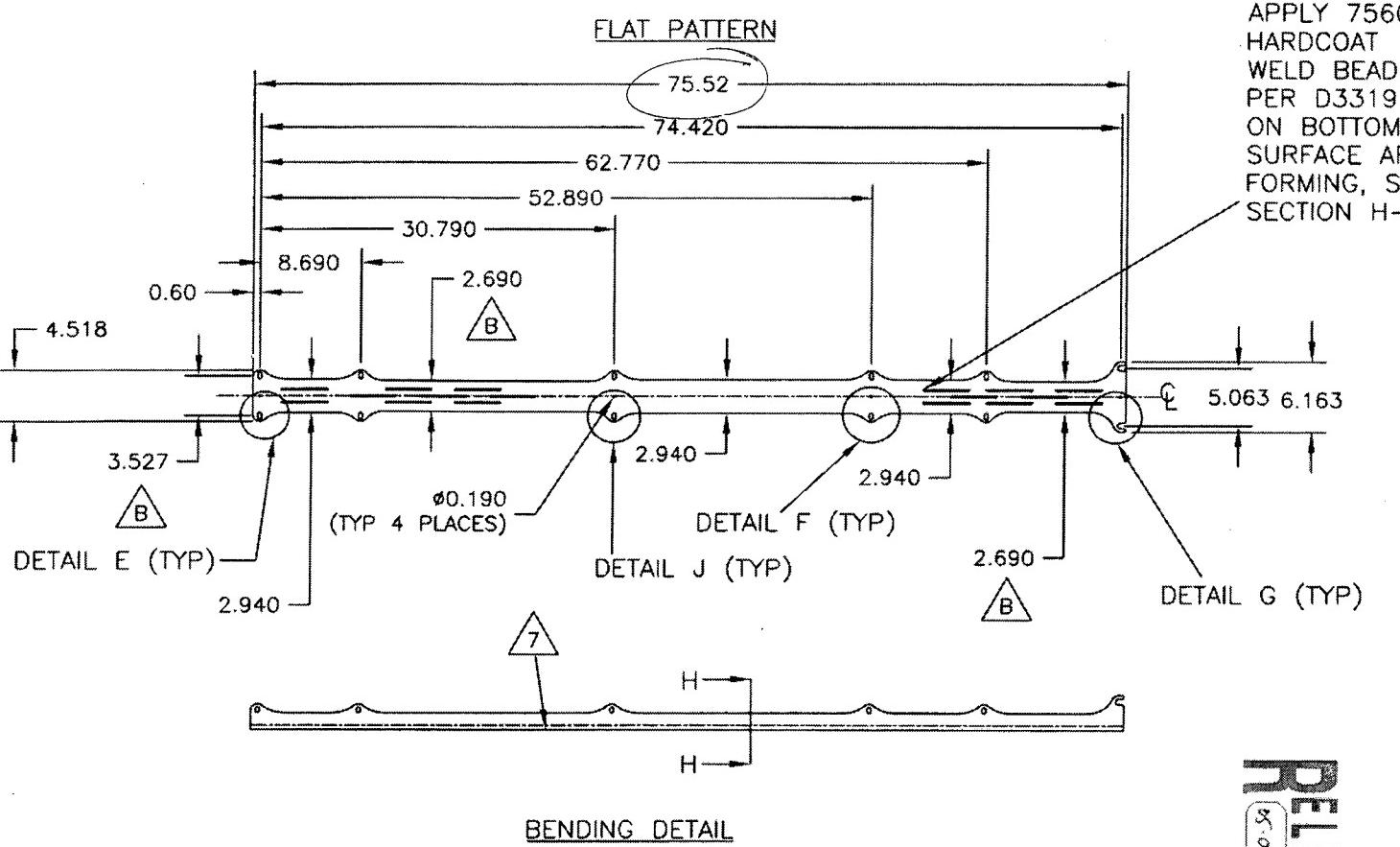
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75190

**DART**

DESIGN DRAWN BY <i>PJ</i>	DRAWN BY <i>PJ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JM</i>	APPROVED <i>JM</i>	DRAWING NO. D3319
DATE 05.06.06	DATE 05.06.06	TITLE WEARPLATE

**RELEASED**D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

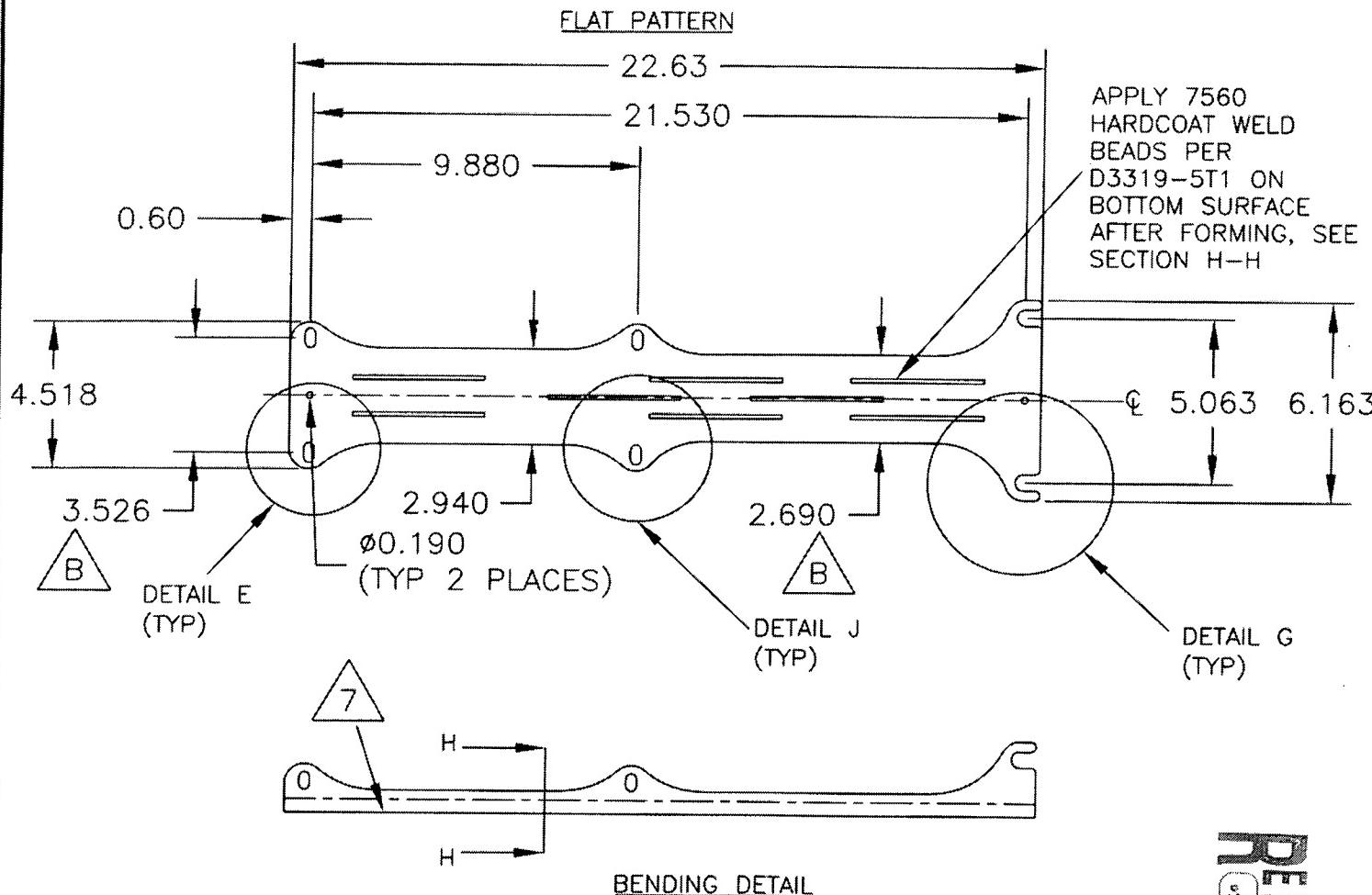
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75190



DESIGN P41	DRAWN BY P41	DART AEROSPACE LTD	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319	HAWKESBURY, ONTARIO, CANADA
DATE 05.06.06		TITLE WEARPLATE	REV. B SHEET 3 OF 5 SCALE 1:5

**RELEASED**  
05.07.30

#### D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

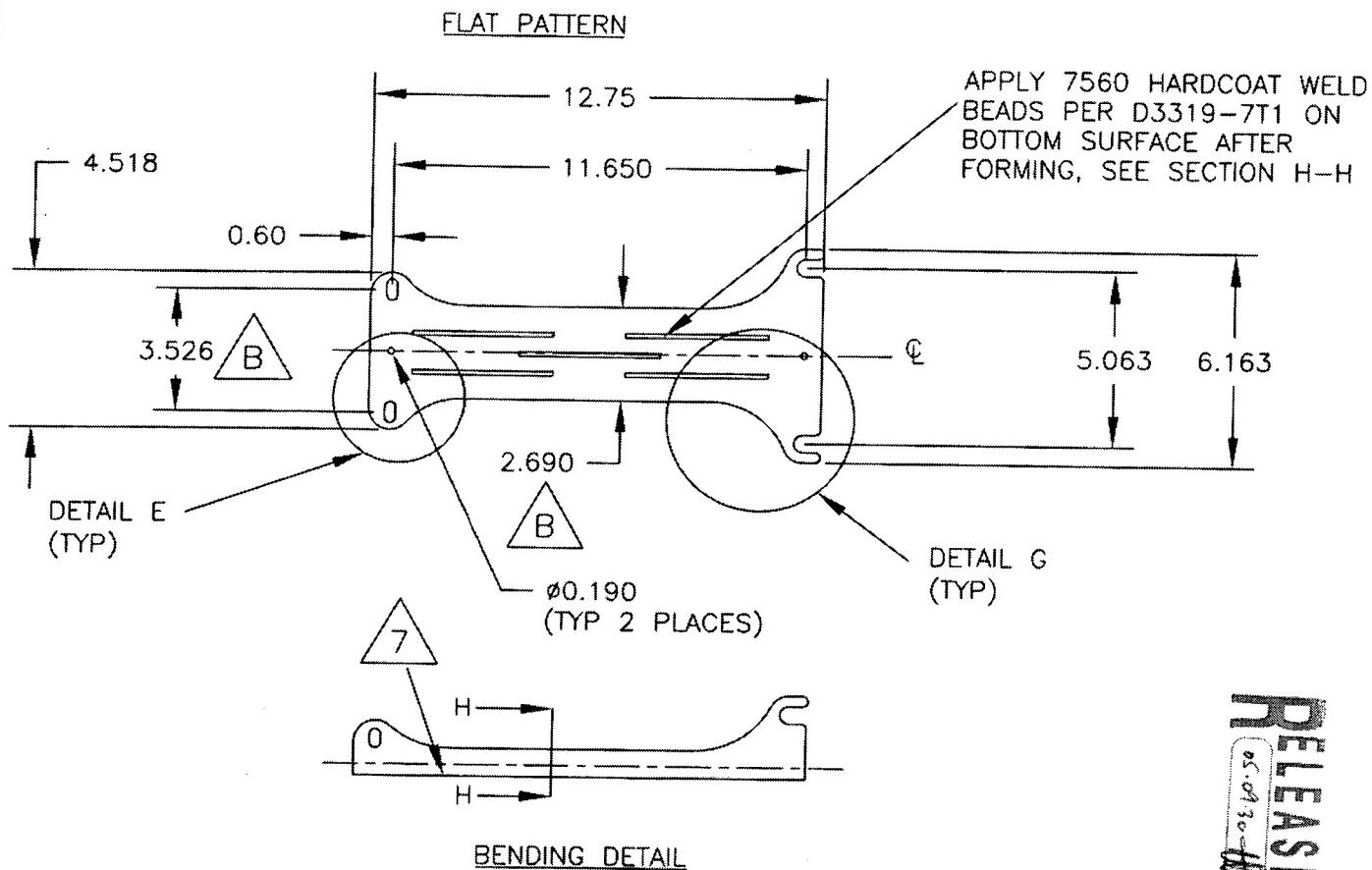
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75190

**DART****RELEASED**  
05.09.30-44

DESIGN P/N	DRAWN BY P/N	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	REV. B SHEET 4 OF 5 SCALE 1:5

D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries